

Date: Wednesday, 4/4/2007 8:57:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 BEARPAW
Job Number	: 31589A		
Estimate Number	: 12480		
P.O. Number	: N/A	Part Number	: D35291
This Issue	: 4/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3529 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30634	Drawing Revision	: A
		Material	: N/A
Written By	:	Due Date	: 4/20/2007
Checked & Approved By	: <u>07.04.04</u>	Qty:	17
Comment	: Est Rev: A New Issue 06-06-28 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.2796 sf(s)/Unit Total : 25.5927 sf(s)
 Pick:
 blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)
 Material: Black UHMW 1"(MUHMWB10)
 Batch: M103975

SD 07/04/05 34

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

SD 07/04/05 34

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.04.07 34

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 07/04/10 34

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

PPP 3 31588 07/4/12 34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Yes Date: 07/04/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:57:29 AM
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Drawing Name: R44 BEARPAW

Job Number: 31589A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



34

Comment: FINAL INSPECTION/W/O RELEASE

157104/16

Job Completion



U 2201-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

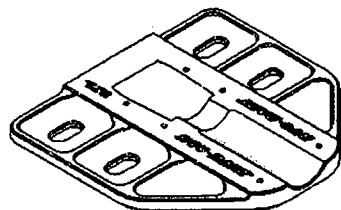
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

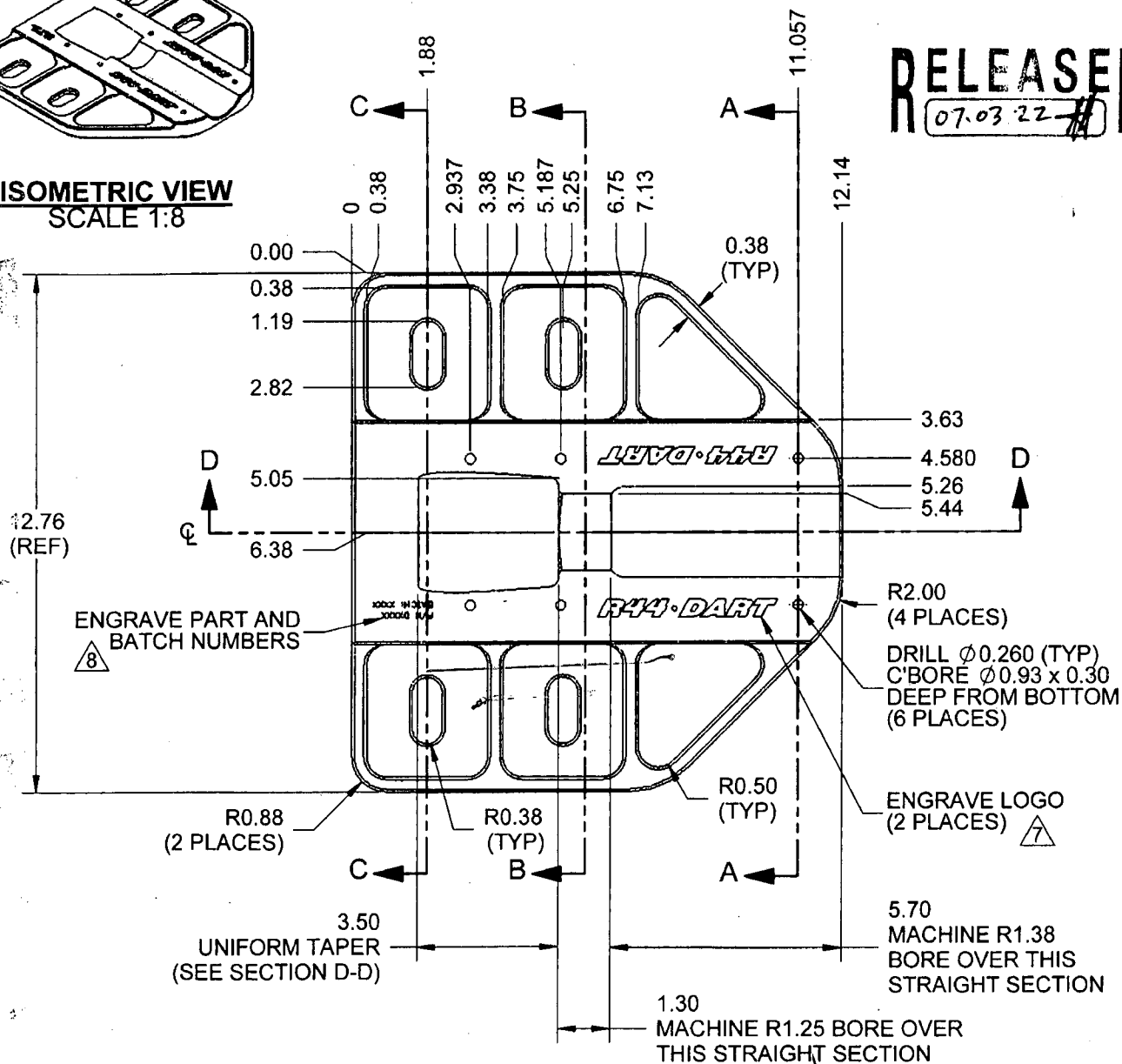


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8

RELEASED
07.03.22



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31589A

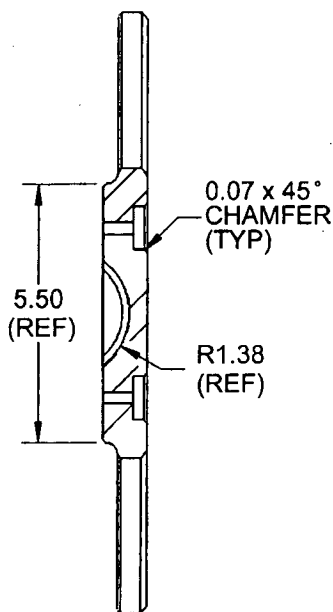
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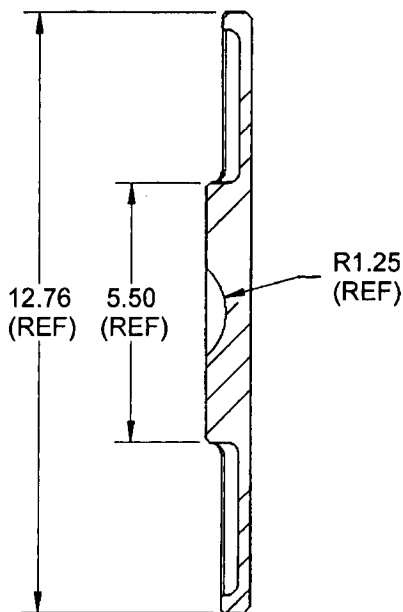


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

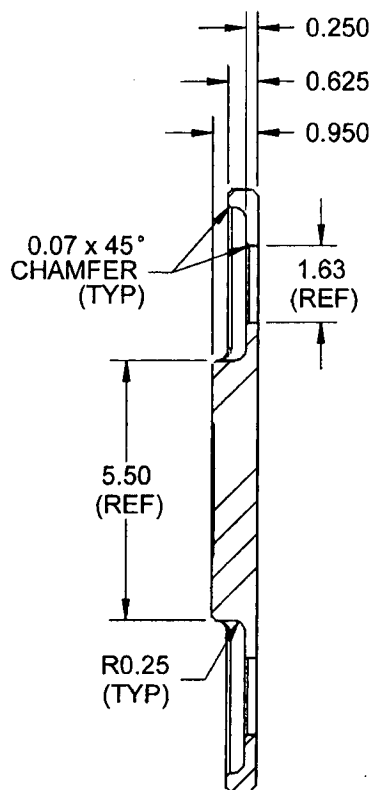
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07.03.22



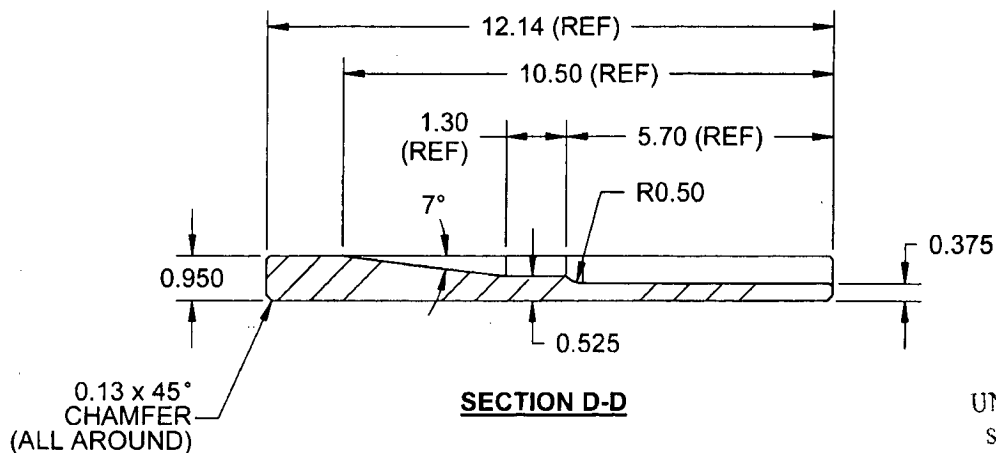
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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DART AEROSPACE LTD	Work Order: 31589A
Description: Bearpaw	Part Number: D3529-1
Inspection Dwg: D3529 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.50	±.030	5.503	—			
B 0.07X45°	±.030	0.051X45°	—			
C R0.25	±.030	R0.250	—			
D 0.250	±.010	0.242	—			
E 0.625	±.010	0.617	—			
F 0.950	±.010	0.951	—			
G 1.63	±.030	1.620	—			
H 12.14	±.030	12.140	—			
I 10.50	±.030	10.530	—			
J 5.70	±.030	5.730	—			
K 0.375	±.010	0.373	—			
L 0.525	±.010	0.523	—			
M 0.13X45°	±.030	0.121X45°	—			
N R0.500	±.030	R0.500	—			
O 12.76	±.030	12.760	—			
P 2.937	±.010	2.939	—			
Q 5.187	±.010	5.191	—			
R 0.38	±.030	0.380	—			
S 11.057	±.010	11.060	—			
T Ø0.260	±.006 ±.001	Ø0.260	—			
U 0.30	±.030	0.309	—			
V Ø0.93	±.030	Ø0.928	—			
W 1.30	±.030	1.281	—			
X						
Y						

Measured by: <i>Qmk</i>	Audited by: <i>J.L</i>	Prototype Approval:	N/A
Date: 07/04/05	Date: 07/04/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	